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(54) **Spreadable water-in-oil emulsion based on a high-melting butterfat fraction and a liquid oil.**

(57) The invention relates to a spreadable water-in-oil emulsion based on a high melting butterfat fraction and a liquid oil which is free of solid fat crystals at 5°C and to a process for producing said emulsion. The use of a high melting fraction obtained by dry fractionation at 15-30°C, as one of the fat components of the fatty phase of the emulsion enables the incorporation of up to 80% of liquid oil, preferably an oil having a relatively high level of polyunsaturated fatty acids.

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SPREADABLE WATER-IN-OIL EMULSION BASED ON A HIGH-MELTING
BUTTERFAT FRACTION AND A LIQUID OIL

The invention relates to a spreadable water-in-oil emulsion, based on a high-melting butterfat fraction and a liquid oil, as well as to a process for its preparation.

- 5 The preparation of a similar product, starting from cream and a vegetable oil, including a churning step, has been described in British Patent Specification 1 217 395. According to this patent specification a maximum amount of 30% of vegetable oil, based on the total amount of
- 10 fat, can be included in the product, since higher concentrations of oil result in a product having too soft a consistency at room temperature.

- There is a need for a spreadable emulsion including if
- 15 possible a reduced amount of the expensive butterfat and an increased amount of oil, preferably vegetable oil having a high content of unsaturated fatty acids which have a favourable physiological effect, with the further object of obtaining a better spreadability at temperatures ranging
- 20 from 5 - 20°C than that of conventional products.

It was found that a spreadable w/o emulsion can be prepared that satisfies these requirements.

- 25 The emulsion according to the invention comprises:
- (i) an aqueous phase having a pH of from 4.0 to 7.0 and constituting at most 70 percent by weight of the total emulsion;
 - (ii) a fatty phase containing
- 30 (a) a liquid oil which at 10°C is substantially free of solid fat crystals and

(b) a butter stearin fraction having the following solid fat contents:

$$N_{10} = 50-80; N_{20} = 24-45; N_{35} = 3-18.$$

5 The above-mentioned solid fat contents have been measured as N-values according to the methods described in Journal of the American Oil Chemists' Society, 51, 1975, 316 (Van Putte et al).

10 The liquid oil consists preferably of a vegetable oil containing a relatively high level of polyunsaturated fatty acids, such as sunflower oil, soybean oil, safflower oil, cottonseed oil, rapeseed oil, corn oil, groundnut oil, or mixtures thereof.

15

It is also possible to use other vegetable or animal oils or low-melting fractions.

The butter stearine is a fraction obtained by the fractionation of butter in the presence of a solvent such as acetone or hexane, or in the presence of a surface-active substance (so-called Lanza fractionation) or in the absence of a solvent (so-called dry fractionation). Preferably the butter stearin is a fraction obtained by the dry fractionation of butter, as the use of solvents in dissolving and purifying oil causes part of the flavours to disappear when the solvent is removed. The dry fractionation is carried out at a temperature ranging from 15 to 30°C, preferably from 23 to 28°C. The butter stearin obtained by dry fractionation preferably has the following solid fat contents, expressed in N-values:

20
25
30

$$N_{10} = 55-70; N_{20} = 35-45; N_{35} = 8-13.$$

The ratios between the components of the fatty phase of the emulsion are such as to impart to said phase the following preferred solid fat contents:

35

$N_{10} = 15-40$; $N_{20} = 9-20$; $N_{35} = 0-5$.

To satisfy these criteria, the fatty phase will preferably contain 20-65 wt% of butter stearin and 35-80 wt%,
5 preferably 40-65 wt% of liquid oil.

The emulsions according to the invention may also contain a certain amount of non-fractionated butterfat; these emulsions preferably comprise a fatty phase having the
10 following composition: butter stearin 20-65%, liquid oil 35-80% and non-fractionated butterfat 0-45%, it being understood that the sum of the quantities by weight of the three components has to be 100%. This non-fractionated butter is preferably present in a dispersed form in
15 the aqueous phase, which may further contain emulsifiers such as mono- or di-glycerides, lecithin, thickeners, proteins and water-soluble salts. The pH preferably lies between 4.5 and 5.5. The aqueous phase preferably contains 1-10 wt% of milk protein, based on the final product.
20 uct.

A preferred aqueous phase is bacteriologically acidified skim milk. As a rule the aqueous phase constitutes about 16 wt% of the total composition.

25

In principle however, the emulsions may be of the low calorie type and constitute about 16 wt%, for example 30-70 wt% of the total composition.

30 The process according to the invention for preparing the emulsion as defined above comprises

- (a) liquefying butterfat and subsequently fractionating and separating the high-melting stearin fraction as
35 defined above;
- (b) preparing a fatty phase starting from the butter stearin thus obtained and a liquid oil which at 10°C is

(c) subjecting the fatty phase thus obtained and an aqueous phase of pH 4.0-7.0 to cooling and working to obtain a spreadable product of the desired texture and plasticity.

5

The butterfat is prepared in a manner known per se, for example starting from cream which is converted into butter, followed by separation of the butter serum, or directly by centrifugation of cream. The butterfat is
10 liquefied by heating it up to a temperature above melting point. Preferably a temperature is chosen which does not exceed 10°C above melting point. This maximum heating temperature will in most cases approximate 45°C. Ideally, the butterfat is brought to a temperature ranging from
15 35° to 40°C.

The fractionation conditions have already been described above.

20 For the preparation of the spreadable product it is possible to dose the fatty and aqueous phases separately into an apparatus in which the cooling and working are effected.

25 It is also possible first to prepare a pre-emulsion, which is subsequently fed to the apparatus. Cooling and working of the emulsion can be carried out in a so-called Votator apparatus, consisting of one or more scraped-surface coolers in which the emulsion is rapidly deep-cooled, and stirring vessels provided with pins in which
30 post-crystallisation can take place. Apparatus of this type is described in Andersen & Williams: "Margarine", Pergamon Press, 2nd Ed., 1965.

According to another embodiment of the invention a cream is prepared starting from a mixture of butter stearin, liquid oil and optionally non-fractionated butterfat, which is injected into water or into diluted or non-diluted skim milk; followed by churning of the mixture, if desired after addition of a further amount of fat, particularly liquid oil.

The invention will now be illustrated by means of the following Examples:

EXAMPLE I

(A) - Preparation of butterfat

Butterfat was prepared, starting from cream having a fat content of 38%, by centrifugation, followed by separation of the butterfat.

(B) - Preparation of butter stearin

Butterfat was heated to 40°C and subsequently cooled (3°C/h) to 25°C.

The stearin obtained had the following characteristics:

$$N_{10} = 65$$

$$N_{20} = 40$$

$$N_{35} = 12$$

(C) - Preparation of the fatty phase

The fatty phase was prepared by mixing at 40°C:

40% of sunflower oil

40% of butterfat (non-fractionated)

20% of stearin.

The fat mixture has the following characteristics:

$$N_{10} = 25$$

$$N_{20} = 12$$

$$N_{35} = 0.5.$$

5

(D) - Preparation of a pre-emulsion

An aqueous phase (16% - pH 4.7), containing acidified skim milk, was emulsified in the above-mentioned fatty
10 phase (84%), in which 0.1% of monoglyceride had been incorporated. The spread was prepared by feeding the pre-emulsion to Votator units according to the following scheme: A A C A, in which in a so-called A unit the pre-emulsions were rapidly cooled and worked and post-
15 crystallisation took place in the so-called C unit.

The residence time in the A unit was 20 - 30 sec. and in the C-unit about 2 min.

20 On emerging from the first A unit the emulsion had a temperature of 15°C; on emerging from the second A unit this temperature was 10°C. On emerging from the C unit the emulsion temperature was 13°C and on emerging from the third A unit 10°C.

25

The hardness, expressed in C-values (determination according to Haighton et al - Journal of American Oil Chemmists' Society 36 (1959) 345) was:

30

$$C_5 = 1400 \text{ g/cm}^2$$

$$C_{10} = 800 \text{ g/cm}^2$$

$$C_{20} = 100 \text{ g/cm}^2$$

The product was excellently spreadable at 5 and 20°C.

EXAMPLE II

The process prescribed according to Example I was repeated, except that the fractionation was carried out at 15°C, resulting in a stearin having the following solid fat contents:

$$N_{10} = 55$$

$$N_{20} = 30$$

$$N_{35} = 4.$$

10

A fatty phase was prepared starting from 60% of stearin and 40% of sunflower oil.

The solid fat contents were as follows:

15

$$N_{10} = 30$$

$$N_{20} = 14$$

$$N_{35} = 0.7.$$

The spread emerging from the Votator had the following characteristics:

20

$$C_5 = 2100 \text{ g/cm}^2$$

$$C_{10} = 1300 \text{ g/cm}^2$$

$$C_{20} = 150 \text{ g/cm}^2$$

The product was eminently spreadable at 10 and 20°C.

25

EXAMPLE III

The process prescribed according to Example I was repeated, except that the fatty phase had been prepared starting from 60% of soybean oil and 40% of stearin.

30

The fat mixture had the following percentages of solid fat:

$$N_{10} = 20$$

$$N_{20} = 11$$

$$N_{35} = 1.0.$$

- 5 The spread emerging from the Votator had the following characteristics:

$$C_5 = 700 \text{ g/cm}^2$$

$$C_{10} = 400 \text{ g/cm}^2$$

$$C_{20} = 90 \text{ g/cm}^2.$$

10

The product was eminently spreadable at 5 and at 20°C.

EXAMPLE IV

- 15 The process prescribed according to Example I for the preparation of the butter stearin was repeated. A fatty phase was prepared, starting from 40 parts of butterfat, 20 parts of butter stearin and 20 parts of sunflower oil. Subsequently an artificial cream was prepared by injecting
20 this fatty phase into 60 parts of skim milk and 60 parts of water. This artificial cream was allowed to stand overnight at 10°C. Subsequently 20 parts of sunflower oil were added and the pre-emulsion was churned until, besides skim milk, a product with the desired texture and plastic-
25 ity was obtained.

The product was eminently spreadable at 10 and 20°C.

Comparative Example

30

- A pre-emulsion was prepared, starting from the aqueous phase of Example I and a fatty phase consisting of 40% of sunflower oil and 60% of non-fractionated butterfat, and was treated according to the process prescribed in Example
35 I. The product thus obtained had the following C-values:

C_5 = approximately 900 g/cm²

C_{10} = approximately 300 g/cm²

At 15° and 20°C the product had no measurable C-value and
5 it was substantially liquid.

C L A I M S

1. Spreadable water-in-oil emulsion comprising:
 - (i) an aqueous phase having a pH of from 4.0 to 7.0 and constituting at most 70 per cent by weight of the total emulsion;
 - 5 (ii) a fatty phase containing
 - (a) a liquid oil which at 10°C is substantially free of solid fat crystals and
 - (b) a butter stearin fraction having the following solid fat contents:
10 $N_{10} = 50-80$; $N_{20} = 25-45$; $N_{35} = 3-18$.
2. Emulsion according to claim 1, characterized in that the ratios between the components of the fatty phase are such as to impart to the fatty phase the following solid
15 fat contents:
 $N_{10} = 15-40$; $N_{20} = 8-20$; $N_{35} = 0-5$.
3. Emulsion according to claim 1, characterized in that the liquid oil consists of sunflower oil, soybean oil,
20 safflower oil, cottonseed oil, rapeseed oil, corn oil, groundnut oil or mixtures thereof.
4. Emulsion according to claim 1, characterized in that the butter stearin is a fraction obtained by fraction-
25 ating butterfat at a temperature ranging from 15° to 30°C, in the absence of a solvent.
5. Emulsion according to claim 4, characterized in that the butter stearin has been obtained by fractionating
30 butter fat at a temperature ranging from 23° and 28°C in the absence of a solvent.

6. Emulsion according to claim 1, characterized in that the fatty phase contains from 20 to 65 per cent by weight of butter stearin and from 35 to 80 per cent by weight of liquid oil.
- 5
7. Emulsion according to claim 6, characterized in that the fatty phase contains from 40 to 65 per cent by weight of liquid oil.
- 10
8. Emulsion according to claim 6, characterized in that it contains from 20 to 60 per cent by weight of butter stearin and from 0 to 45 per cent by weight of non-fractionated butterfat.
- 15
9. Emulsion according to claim 1, characterized in that the aqueous phase consists of a cream.
10. Emulsion according to claim 9, characterized in that the cream contains non-fractionated butterfat.
- 20
11. Process for preparing a spreadable emulsion according to claim 1, characterized in that
 - (a) butterfat is liquefied and subsequently a high-melting
25 butter stearin is separated therefrom by fractionation, having the following solid fat contents:
$$N_{10} = 50-80; N_{20} = 25-45; N_{35} = 3-18;$$
 - (b) a fatty phase is prepared, starting from the butter
30 stearin fraction obtained in step (a) and a liquid oil which at 10°C is substantially free of solid fat crystals;
 - (c) the fatty phase thus obtained and an aqueous phase of pH = 4.0 - 7.0 are subjected to cooling and working to
35 obtain a spreadable product of the desired texture and plasticity.

12. Process according to claim 11, characterized in that the fractionation is carried out in the absence of a solvent at a temperature ranging from 15° to 30°C.
- 5 13. Process according to claim 12, characterized in that the fractionation is carried out at a temperature ranging from 23° to 28°C.
- 10 14. Process according to claim 11, characterized in that the fatty and aqueous phases are separately fed to an apparatus in which they are subjected to cooling and working.
- 15 15. Process according to claim 11, characterized in that starting from the fatty phase and the aqueous phase a pre-emulsion is prepared, which is subsequently fed to an apparatus in which the emulsion is cooled and worked.
- 20 16. Process according to claim 11, characterized in that cream is prepared starting from a mixture of butter stearin, liquid oil and optionally non-fractionated butter-fat, which is injected into water or into diluted or non-diluted skim milk, after which the mixture thus obtained is churned, optionally after addition of a further amount
25 of fat.



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
A	US-A-4 051 269 (O.B.S.STRINNING) *Claim 1; example 2*	1	A 23 D 3/00 C 11 B 7/00 A 23 C 15/14
A	CH-A- 594 360 (MJÖLKCENTRALEN) *Claim; column 3, lines 17-60*	1	
A	US-A-1 467 081 (E.E.AYRES) *Claims 1,5; page 1, column 1, lines 9-13*	1	
A	US-A-1 342 827 (A.SCHWARCMAN) *Claim 1; page 2, lines 30-41*	1	
A	CHEMICAL ABSTRACTS, vol. 94, no. 13, March 1981, page 593, no. 101532w, Columbus Ohio (USA); J.M.De Man et al.: "Characteristics of milk fat fractionated by crystallization from the melt". & CAN. INST. FOOD SCI. TECHNOL. J. 1980, 13(4), 167-73. *Abstract*	1-3	TECHNICAL FIELDS SEARCHED (Int. Cl. 3) A 23 C A 23 D C 11 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 26-07-1982	Examiner PEETERS J.C.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			